

Work Order ID 146306 -2

146306

Page 1

Tuesday, May 17, 2016 10:51:37 AM

Item ID: D117-837-111 *SPLIT* Accept **N900040100** Setup Start **NS1**

Revision ID: *3* Item Name: BK117 Basket Mounting Provisions Stop **NS2**

Start Date: 5/18/2016 Start Qty: 2.00 **2** Cust Item ID:

Required Date: 5/27/2016 Req'd Qty: 2.00 **2** Customer:

Reference:

Approvals: Process Plan: *sm* Date: *16/05/17* Tooling: Date: Run Start **NR1**
QC: Date: SPC (Y/N): Date: Stop **NR2**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI9724	A
IIN-D117-837	B

100	Document Control	0.00							
<i>*100*</i>	DOCUMENT CONTROL								
100	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D117-837-111 CHG003								

110	Pick Kit	0.00							
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<i>*110*</i>									
Packaging	Memo	0.00							
Packaging									

MAY 18 2016

DAS
27
9-89

MAY 27 2016

DAS
28
9-89

MAY 29 2016

MLJ 10-05-27
(3)



Work Order ID 146306

Tuesday, May 17, 2016 10:51:37 AM

146306

Page 2

Item ID: D117-837-111 Accept *N900040100* Setup Start *NS1*

Revision ID: Item Name: BK117 Basket Mounting Provisions Stop *NS2*

Start Date: 5/18/2016 Start Qty: 2.00 *2* Cust Item ID:

Required Date: 5/27/2016 Req'd Qty: 2.00 *2* Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 *120* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.06				27 9-89			
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MAY 27 2016

130 *130* Packaging Packaging	Packaging Memo identify and pack for shipping as per PPP D117-837-111 Location: _____	0.00 0.00				27 9-89			
--	--	------------------	--	--	--	------------	--	--	--

MAY 27 2016

140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.20							
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MAY JUN 03 2016



Picklist Print

Tuesday, May 17, 2016 10:51:43 AM

Page 1

Work Order ID: 146306

146306

Parent Item: D117-837-111

D117-837-111

Parent Item Name: BK117 Basket Mounting Provisions

Start Date: 5/18/2016

Required Date: 5/27/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 13.03.28 NEW ISSUE DD VERF:JLM IPP
REV:B 13.06.21 IIN-D117-837 REV.A DD VERF:JFS IPP REV:C
14.07.25 ecn 14-571/ chg002 DD VERF:JLM IPP REV:D 15.05.27 add
DSI9727 as per ecn15-571 DD verf:jlmm

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-13A *AN4-13A* Bolt		Purchased	No				Each	325.0000	4/ 812	**			
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				FG	20								
				122808	20								
				GA	60								
				m134167	36								
				m134634	24								
				O003	200								
				m134754	200								
				ST344	45								
				m134634	45								
D5253-1 *D5253-1* Shim		Manufactured	No				Each	36.0000	4/ 812	**			
				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				ST161	36								
				144608	36								
D4893-1 *D4893-1* Hard Point Adapter, LH		Manufactured	No				Each	0.0000	2 4 6	**			
D4893-2 *D4893-2* Hard Point Adapter, RH		Manufactured	No				Each	0.0000	2 4 6	**			

MAY 19 2016



Picklist Print

Tuesday, May 17, 2016 10:51:43 AM

Page 2

Work Order ID: 146306

146306

Parent Item: D117-837-111

D117-837-111

Parent Item Name: BK117 Basket Mounting Provisions

Start Date: 5/18/2016

Required Date: 5/27/2016

Start Qty: 2.00

Required Qty: 2.00

D4894-1 Manufactured No

Each 1.0000

D4894-1

Fwd Beam

**

1 23

144931x2

DAS

6

9-89

DAS

26

9-89

Location

Loc Qty

Loc Code

ST447

1

122818

1

Each

2.0000

**

1x

23

144932

DAS

6

9-89

DAS

26

9-89

D4894-3 Manufactured No

D4894-3

Aft Beam

Location

Loc Qty

Loc Code

ST447

2

121292

2

Each

1.0000

**

2

23

144933x2

DAS

6

9-89

D4895-045 Manufactured No

D4895-045

Fwd Outboard Beam Assembly

Location

Loc Qty

Loc Code

ST478

1

136931

1

Each

0.0000

**

1

23

144934x2

MAY 24 2016

DAS

6

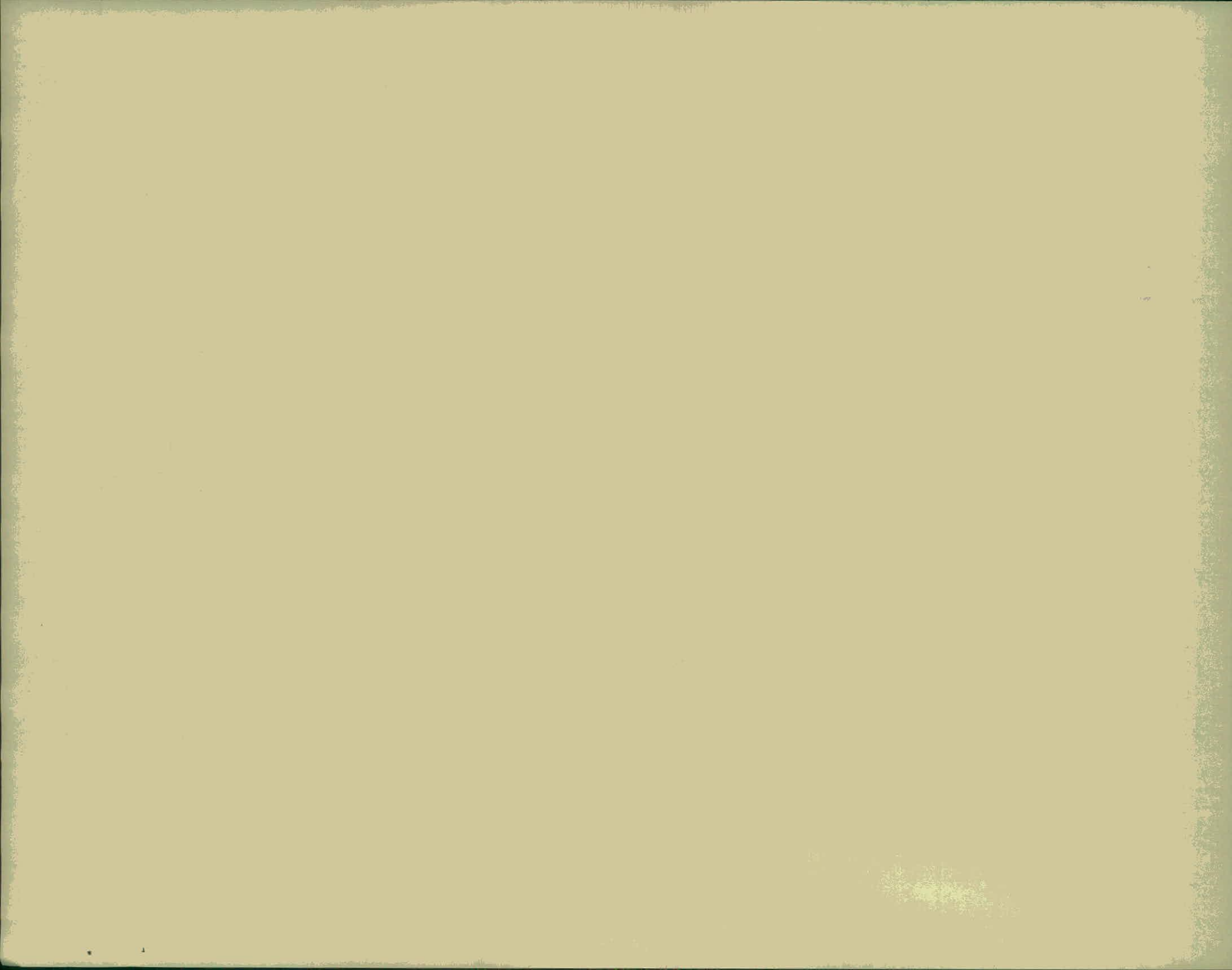
9-89

D4895-047 Manufactured No

D4895-047

Aft Outboard Beam Assembly

144934x1



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Work Order ID: 146306

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Parent Item: D117-837-111

D117-837-111

Parent Item Name: BK117 Basket Mounting Provisions

Start Date: 5/18/2016

Required Date: 5/27/2016

Start Qty: 2.00

Required Qty: 2.00

AN4-17A Purchased No

Each 261.0000

48 12

AN4-17A

Bolt

**

DAS
27
9-89

Location

Loc Qty

Loc Code

over003

200

M134508

50

M134573

50

M134634

50

M134754

50

ST343

61

M133998

61

ANS-23A

Purchased No

Each 43.0000

12 24 36

AN5-23A

Bolt

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST337

43

M134634

43

MS20002C6

Purchased No

Each 164.0000

12 24 36

MS20002C6

WASHER

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST314

164

m132823

64

m134754

100

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Picklist Print

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Work Order ID: 146306

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Parent Item: D117-837-111

D117-837-111

Parent Item Name: BK117 Basket Mounting Provisions

Start Date: 5/18/2016

Required Date: 5/27/2016

Start Qty: 2.00

Required Qty: 2.00

MS21042L4

Purchased

No

Each

2,185.000

8 16 24

MS21042L4

Locknut

**

AS
27
9-89

Location

Loc Qty

Loc Code

GA 187

m133769 187

OVER007 1500

m134676 500

m134762 1000

ST303 401

m134606 401

ST305 97

m130922 97

24

MS21042L5

Purchased

No

Each

601.0000

12 24 36

MS21042L5

Nut

**

AS
27
9-89

Location

Loc Qty

Loc Code

GA 101

m127813 101

OVER007 100

m134509 100

ST303 400

m134055 7

m134567 93

m134676 100

m134762 200

36

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Picklist Print

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Work Order ID: 146306

146306

Parent Item: D117-837-111

D117-837-111

Parent Item Name: BK117 Basket Mounting Provisions

Start Date: 5/18/2016

Required Date: 5/27/2016

Start Qty: 2.00

Required Qty: 2.00

MS21042L6

Purchased No

Each 263.0000

12 24 36

MS21042L6

Nut

**

DAS

DAS

6

28

9-89

9-89

Location

Loc Qty

Loc Code

ST303

263

m133938

6

m134055

7

m134509

100

m134567

50

m134676

100

36

DAS

6

9-89

MS21250-06022

Purchased No

Each 59.0000

12 24 36

MS21250-06022

BOLT

**

DAS

28

9-89

Location

Loc Qty

Loc Code

over000

36

M134676

36

ST294

23

M129688

8

M134762

15

36

NAS1149D0416J

Purchased No

Each 4,208.000

16 32 48

NAS1149D0416J

WASHER

**

DAS

28

9-89

Location

Loc Qty

Loc Code

GA

222

m131511

222

ST260a

1984

m131511

1984

ST264

2002

m131511

2002

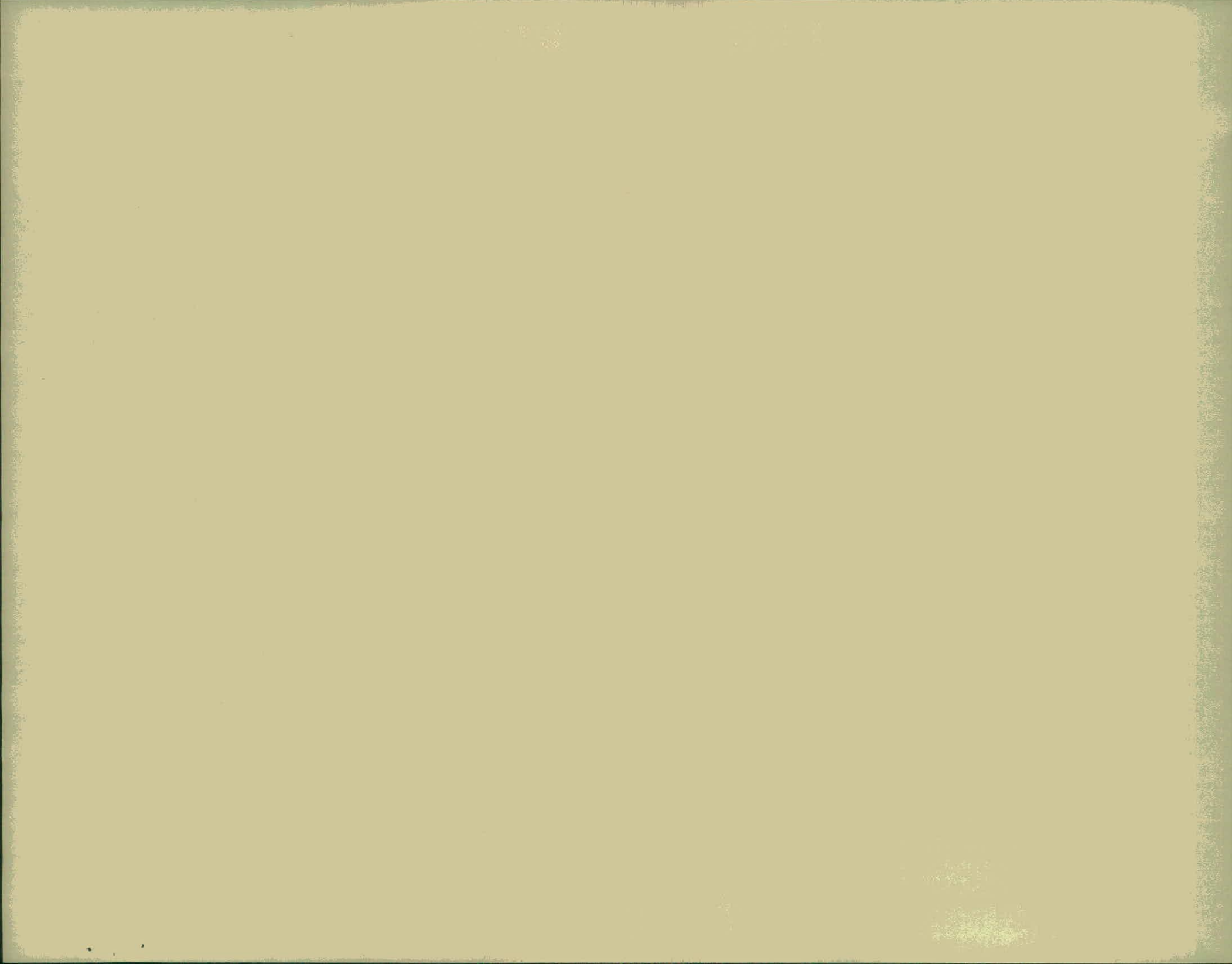
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MAY 19 2016

Tuesday, May 17, 2016 10:51:44 AM

Shop Packet Print

Page 5



Picklist Print

Tuesday, May 17, 2016 10:51:44 AM

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Work Order ID: 146306

146306

Parent Item: D117-837-111

D117-837-111

Parent Item Name: BK117 Basket Mounting Provisions

Start Date: 5/18/2016

Required Date: 5/27/2016

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0516J

Purchased

No

Each

111.0000

24 48 72

NAS1149D0516.I

Washer

**

NAS

27

9-89

Location

ST264

Loc Qty

111

Loc Code

M129706

111

Each

170.0000

72
12 24 36

**

NAS1149D0616J

Purchased

No

NAS1149D0616.I

WASHER

Location

ST264

Loc Qty

170

Loc Code

122815

170

NAS

27

9-89

MAY 19 2016

76



DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D117-837 REV. B AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D117-837 REV. 1
REF. TCCA STC: SH13-22
REF. FAA STC: SR03353NY

1.0 Purpose

Some customers have experienced problems with the alignment of the quick release pins after installing the D117-837-011 Basket kit after CHG 003. The purpose of this DSI is to provide instructions and parts to correct this mis-alignment. The DSI 9724-011 Shim Kit provides tapered shims that may be installed between the D5106-041 Bracket Assemblies and the bottom rib of the D4784-041 Basket Assembly.

2.0 Installing D5253-1 Shims

- 2.1 Unfasten D5106-041 Bracket Assy from D4784-041 Basket Assy.
- 2.2 Replace AN4-12A bolts with AN4-13A bolts and install D5253-1 shims as shown in Figure 1, using 2x NAS1149D0416J washers and 1 x MS21042L4 nut per shim. Pay attention to the orientation of the shim in relation with the basket center. Position the 4x D5253-1 Shims with the thicker side away from the center of the basket.
- 2.3 Fasten D5106-041 Bracket Assy to D4784-041 Basket Assy.
- 2.4 Continue with step 3.1.3 of IIN-D117-837 Rev. B.

3.0 Parts List

For D117-837-011 Heli-Utility-Baskets @ CHG 003 and later, the DSI 9724-011 Shim Kit is available from Dart. The parts in the DSI 9724-011 Shim Kit have been added to D117-837-011 Basket Kits @ CHG 006 and later.

Qty -011	Part Number	Description
X	DSI 9724-011	SHIM KIT
4	D5253-1	SHIM
4	AN4-13A	BOLT
4	MS21042L4	NUT
8	NAS1149D0416J	WASHER

4.0 Weight & Balance

This DSI has a negligible effect on Weight & Balance

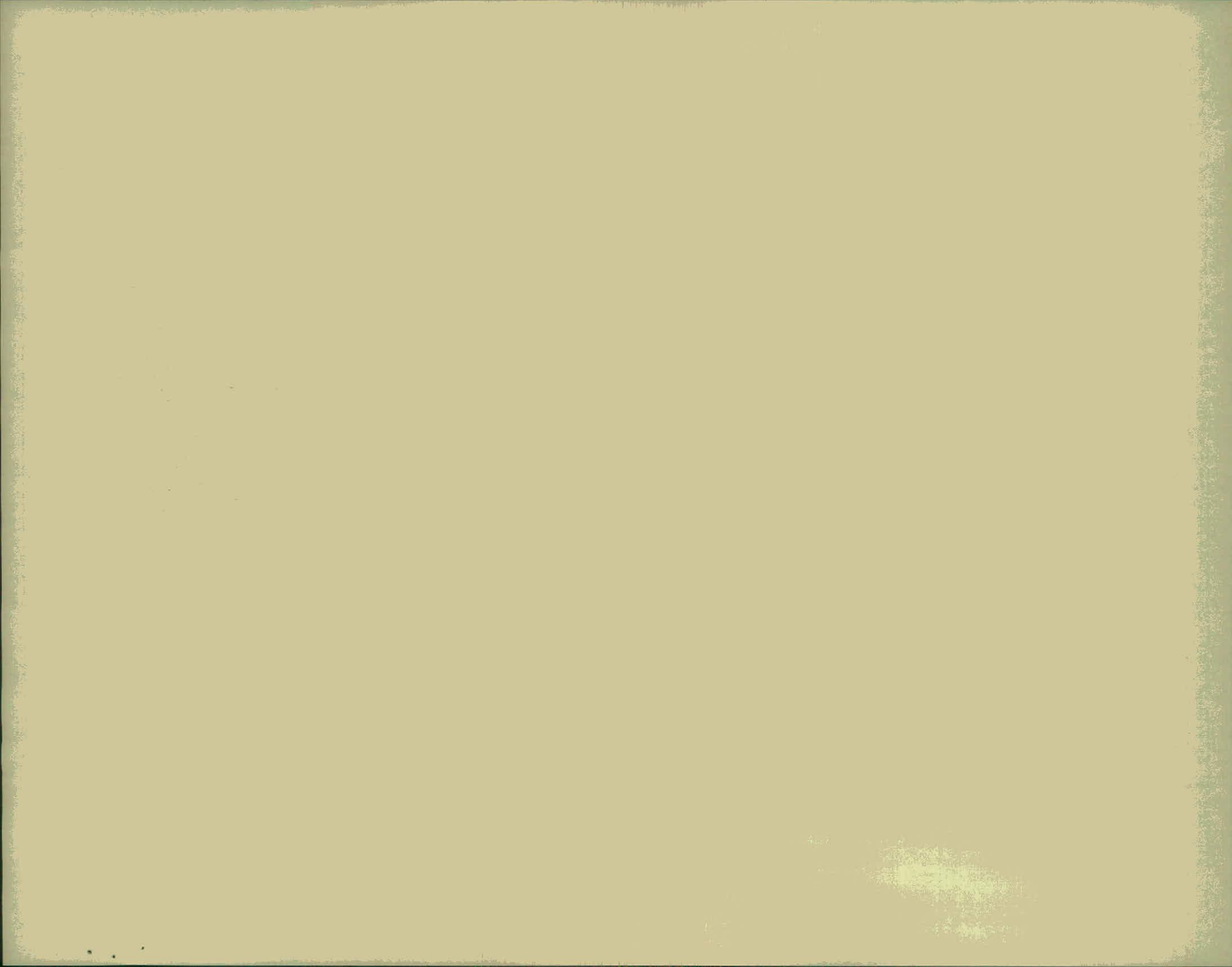
CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 15.05.11
CERT. NO.: SH13-22
ISSUE NO.: 1

A	NEW ISSUE	RF	15.05.11
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HS	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9724	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SHIM KIT	NTS
DATE	15.05.11	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



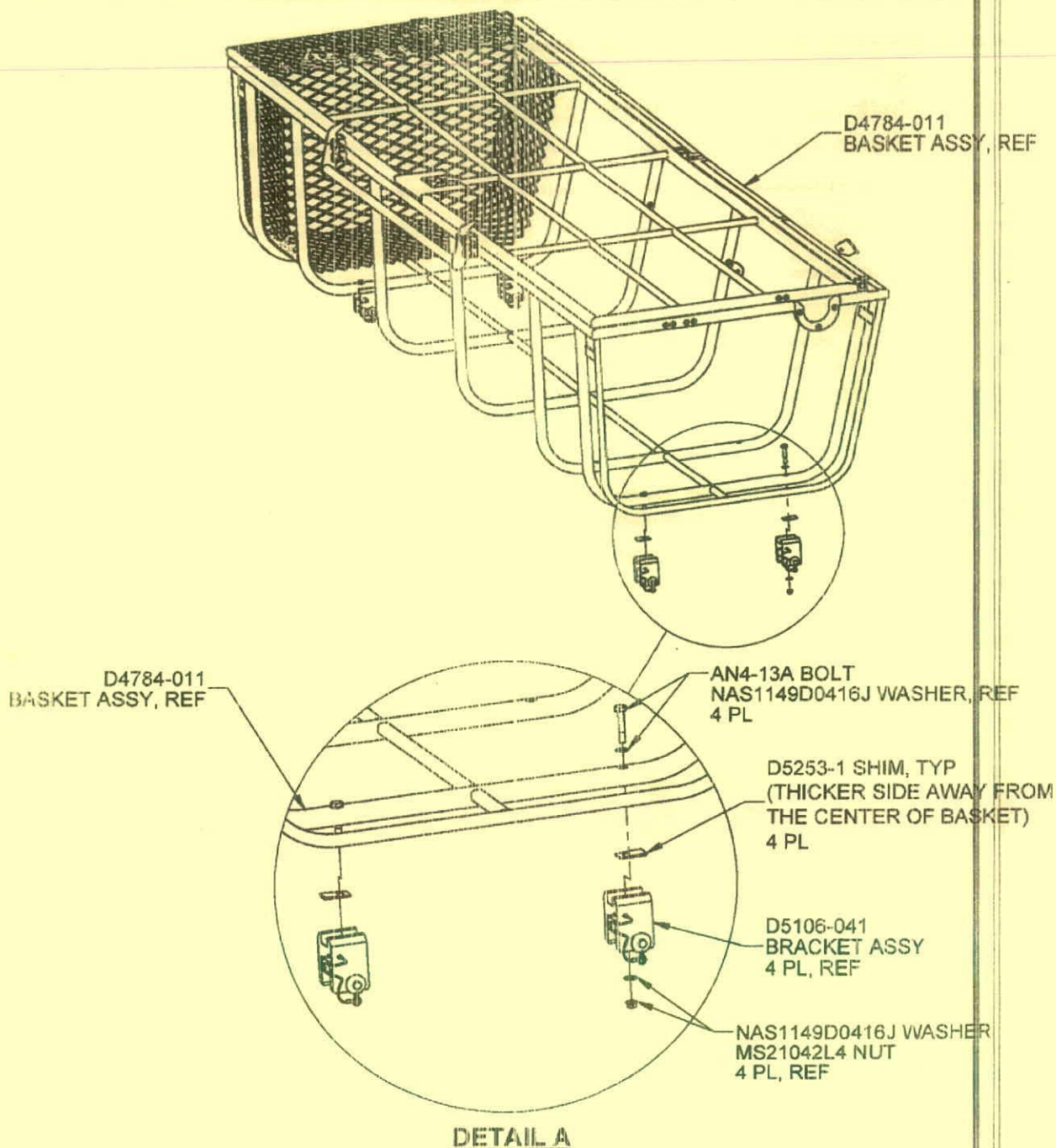


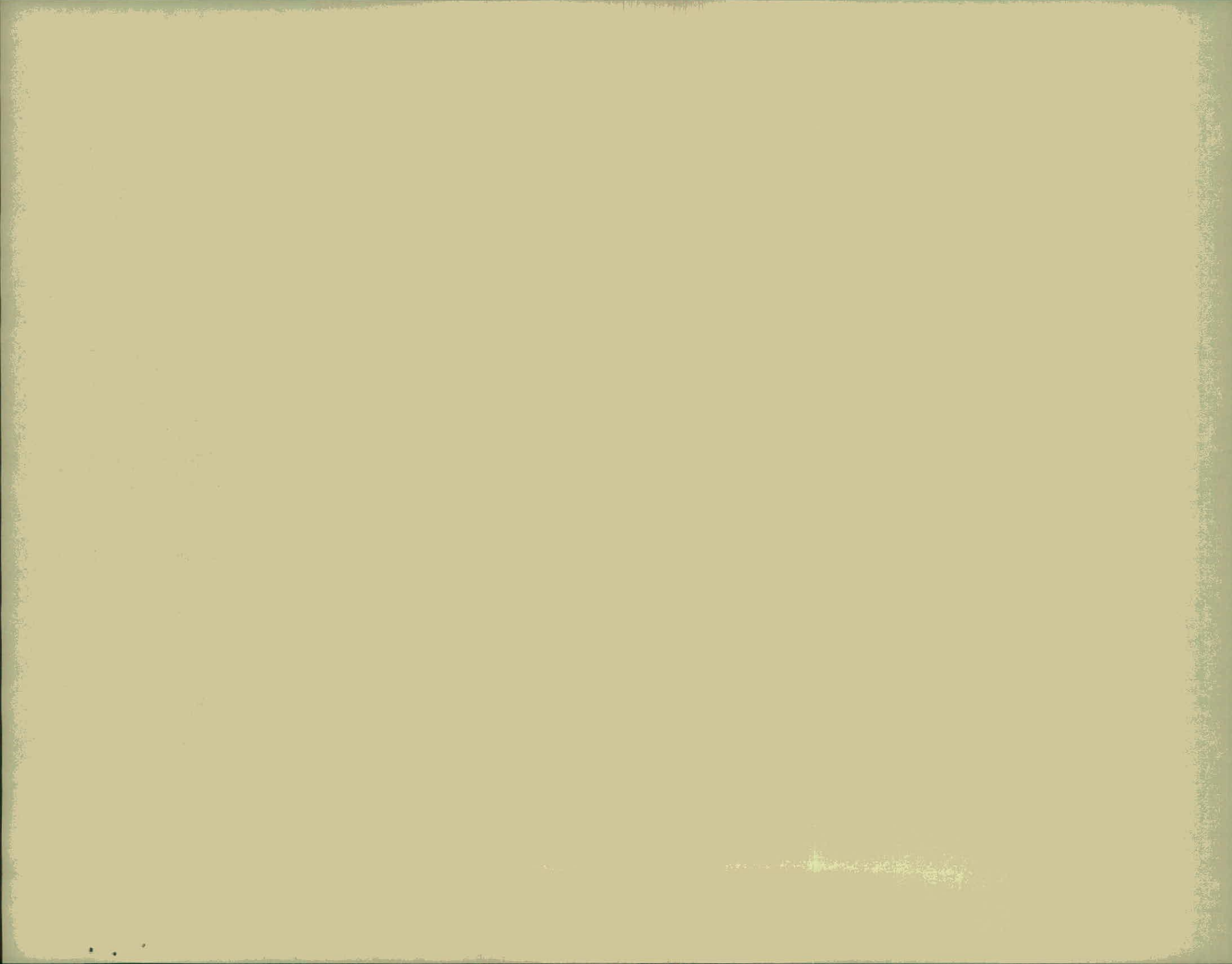
FIGURE 1 - D5253-1 SHIM INSTALLATION

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 15.05.11
CERT. NO.: SH13-22
ISSUE NO.: 1

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HS	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9724	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.		SHIM KIT	NTS
DATE	15.05.11	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



5.0 PARTS LIST

Qty -011	Qty -013	Qty -111	Part Number	Description
X			D117-837-011	HELL-UTILITY-BASKET, LH/RH
	X		D117-837-013	PROP ARM KIT
1		X	D117-837-111	BASKET PROVISION MOUNTING KIT
	1*		D2332-041	PROP ASSEMBLY (OPTIONAL)
	4*		D3953-9	WASHER
1			D4784-011	BASKET ASSEMBLY, HEAVY DUTY, LH/RH
1			D4794-043	STRUT ASSY
		2	D4893-1	HAFDPOINT ADAPTER, LH
		2	D4893-2	HAFDPOINT ADAPTER, RH
		1	D4894-1	FWD BEAM
		1	D4894-3	AFT BEAM
		1	D4895-045	FWD OUTBOARD BEAM ASSY
		1	D4895-047	AFT OUTBOARD BEAM ASSY
1			D4911-1	BRACKET
2			D4911-3	BRACKET
4			D5106-041	BRACKET ASSY
2			AN3-11A	BOLT
4			AN4-12A	BOLT
		4	AN4-17A	BOLT
		12	AN5-23A	BOLT
		12	MS20002C6	WASHER
2			MS21042-3	NUT
4		4	MS21042L4	NUT
		12	MS21042L5	NUT
		12	MS21042L6	NUT
4			MS21069L3	ANCHOR NUT
		12	MS21250-06022	BOLT
4			MS27039-1-08	SCREW
8			NAS1097AD3-4	RIVET
	3*		NAS1149C0463R	WASHER (or AN960C416)
8		8	NAS1149D0416J	WASHER (or AN960JD416L)
		24	NAS1149D0516J	WASHER (or AN960JD516L)
		12	NAS1149D0616J	WASHER (or AN960JD616L)
6			NAS1149F0332P	WASHER (or AN960-10L)

* D2332-041 PROP ASSEMBLY & HARDWARE (OPTIONAL) TO REPLACE D3953-9 GAS SPRING



REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D117-837 REV. B AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D117-837 REV. 1
REF. TCCA STC: SH13-22
REF. FAA STC: SR03353NY

1.0 Purpose

Some customers have experienced problems with the alignment of the quick release pins after installing the D117-837-011 Basket kit after CHG 003. The purpose of this DSI is to provide instructions and parts to correct this mis-alignment. The DSI 9724-011 Shim Kit provides tapered shims that may be installed between the D5106-041 Bracket Assemblies and the bottom rib of the D4784-041 Basket Assembly.

2.0 Installing D5253-1 Shims

- 2.1 Unfasten D5106-041 Bracket Assy from D4784-041 Basket Assy.
- 2.2 Replace AN4-12A bolts with AN4-13A bolts and install D5253-1 shims as shown in Figure 1, using 2x NAS1149D0416J washers and 1 x MS21042L4 nut per shim. Pay attention to the orientation of the shim in relation with the basket center. Position the 4x D5253-1 Shims with the thicker side away from the center of the basket.
- 2.3 Fasten D5106-041 Bracket Assy to D4784-041 Basket Assy.
- 2.4 Continue with step 3.1.3 of IIN-D117-837 Rev. B.

3.0 Parts List

For D117-837-011 Heli-Utility-Baskets @ CHG 003 and later, the DSI 9724-011 Shim Kit is available from Dart. The parts in the DSI 9724-011 Shim Kit have been added to D117-837-011 Basket Kits @ CHG 006 and later.

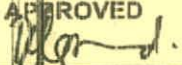
Qty -011	Part Number	Description
X	DSI 9724-011	SHIM KIT
4	D5253-1	SHIM
4	AN4-13A	BOLT
4	MS21042L4	NUT
8	NAS1149D0416J	WASHER

4.0 Weight & Balance

This DSI has a negligible effect on Weight & Balance

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAC # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 15.05.11
CERT. NO.: SH13-22
ISSUE NO.: 1

A	NEW ISSUE	RF	15.05.11
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	HS	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9724	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SHIM KIT	NTS
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